

Date: Tuesday, 12/5/2006 8:19:21 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : CASTING, SUPPORT BRACKET
Job Number : 29807	
Estimate Number : 10935	
P.O. Number : <i>N/A</i>	Part Number : D2265
This Issue : 12/5/2006 S.O. No. : <i>N/A</i>	Drawing Number : D2265 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : PURCHASED PARTS	Drawing Revision : A
Previous Run : 29079	Material : <i>N/A</i>
Written By : <i>JA</i>	Due Date : 1/5/2007 Qty: 50 Um: Each
Checked & Approved By : <i>JA 061205</i>	
Comment : Est D 98.12.15 Added Dwg Rev DM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: PURCHASING

Issue P/O: *2640* *C20612104*

Cast parts per drawing D2265

Possible Supplier: Alpine Foundry

Material release note required

(50)

2.0	D2265P	Step Support Casting
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 50.0000 Each(s)
 Step Support Casting

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Recieve & Inspect for Transit Damage

Ensure Material Release Note is attached

PC 4/12/22 50

4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

MO6/12/22 (50)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Grind tips of castings as per Dwg D2265

SAD / se Dec 12/06

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ P ☐ Date: 07/01/02

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 12/5/2006 8:19:21 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CASTING, SUPPORT BRACKET

Job Number: 29807

Part Number: D2265

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



07-02-02 SD



Comment: INSPECT WORK TO CURRENT STEP

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *SL372*

EB 07/01/02 SD

PV 7/01/02 SD

8.0

QC21

FINAL INSPECTION/W/O RELEASE



SD

Comment: FINAL INSPECTION/W/O RELEASE

SD 07/01/02

Job Completion



CL07101102

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

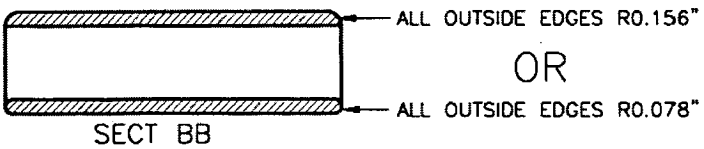
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

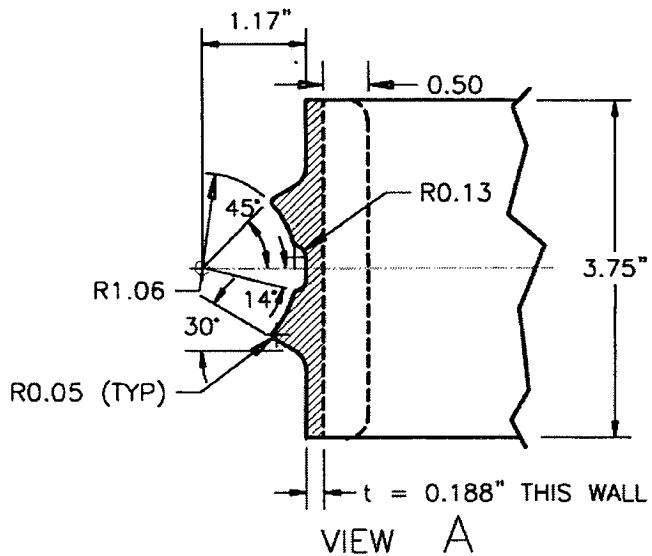
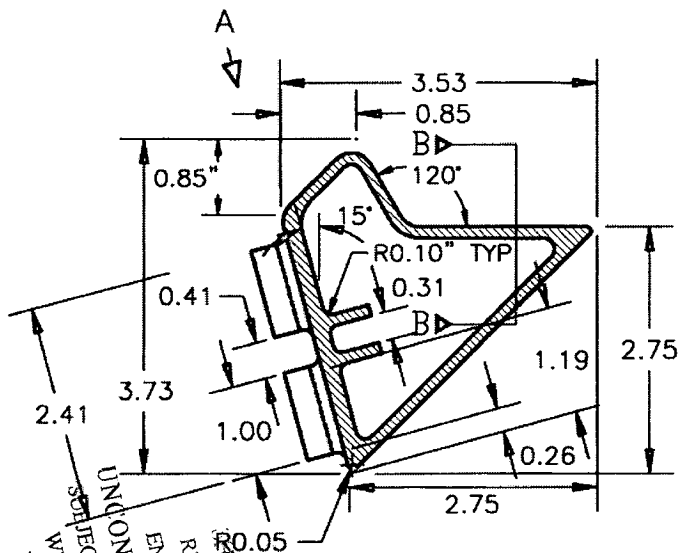


PREPARED B. Williams		DART AERO ACCESSORIES INC VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <input checked="" type="checkbox"/>	APPROVED	D2265	REV. A
DATE Aug. 18, 1994		TITLE STEP SUPPORT CASTING	SHEET 1 OF 1
			SCALE 1:2

RELEASED
96/05/27



UNDIMENSIONED OUTER RADII 0.375"
UNDIMENSIONED INNER RADII 0.25"
UNDIMENSIONED WALL THICKNESSES 5/32"
MATERIAL: CAST ALUMINUM
ALLOY A356.2 (F)



NO. 24807
WORK ORDER
UNCONTROLLED COPY
ENGINEERING
RETURN TO
DEPT COPY
WITHOUT NOTICE
SUBJECT TO AMENDMENT

8657-132ND STREET
SURREY, B.C. V3W 4P1

Tel:(604) 596-8080

Fax: (604) 596-8045

Sold To: DART AEROSPACE
1270 ABERDEEN STREET
HAWKESBURY, ONT
CANADA K6A 1K7

Ship To: DART AEROSPACE

06/12/22

Castings&Patterns are property of Alpine until paid in full

Dec 20/06



Certificat d'analyse / Certificate of analysis

DATE: 2006-06-19

USINE BEAUHARNOIS WORKS

PAGE: 1

N° COMMANDE CLIENT / CUSTOMER ORDER NO.:
R19966 / JUNE 1COMMANDE ALCAN (ITEM/OTA) / ALCAN ORDER NO.:
355-0059049 001 01N° D'EXPÉDITION / SHIP NO.:
CONNAISSEMENT / BILL OF LADING: 6495
TRANSPORTEUR / CARRIER: 327-087703-000
SCÉLLÉS / SEALS: GPGI000000INPROHEAT INDUSTRIES LTD
CONSOLIDATED FAST FRATE INC.
4415 FAIRWAY, ATT. JOE OR BARBARA
PHONE: 514 639 7747
LACHINE, QC, CA
H8T 1B5INPROHEAT INDUSTRIES LTD
680 RAYMUR AVE.
TEL. 604 254-0461
FAX: 604 254 6377
VANCOUVER, BC, CA
V6A 2R1PRODUIT / PRODUCT: ALCAN 44512 A356.2
ALUMINUM INGOT
DIMENSION:

ANALYSE EN % DU POIDS / ANALYSIS IN % OF WEIGHT

NUMÉRO DE COULÉE DROP NUMBER	# ING	LOT #	POIDS NET (KG) NET WEIGHT	PIECES	SI	FE	CU	MN	MG	CR	NI	ZN	TI	PB
					NA	CA	LI	SR						
2229	0815132	081513201	1011	68	7.05	0.10	< 0.01	< 0.01	0.40	< 0.01	< 0.01	< 0.01	0.11	< 0.001
2207	0815132	081513202	1001	68	< 0.001	< 0.001	2 PPM	< 0.001						
					7.05	0.10	< 0.01	< 0.01	0.40	< 0.01	< 0.01	< 0.01	0.11	< 0.001
2248	0815132	081513203	1020	68	< 0.001	< 0.001	2 PPM	< 0.001						
					7.05	0.10	< 0.01	< 0.01	0.40	< 0.01	< 0.01	< 0.01	0.11	< 0.001
2231	0815132	081513204	1012	68	< 0.001	< 0.001	2 PPM	< 0.001						
					7.05	0.10	< 0.01	< 0.01	0.40	< 0.01	< 0.01	< 0.01	0.11	< 0.001
2248	0815132	081513205	1020	68	< 0.001	< 0.001	2 PPM	< 0.001						
					7.05	0.10	< 0.01	< 0.01	0.40	< 0.01	< 0.01	< 0.01	0.11	< 0.001
2264	0815132	081513206	1027	68	< 0.001	< 0.001	2 PPM	< 0.001						
					7.05	0.10	< 0.01	< 0.01	0.40	< 0.01	< 0.01	< 0.01	0.11	< 0.001
2244	0815132	081513207	1018	68	< 0.001	< 0.001	2 PPM	< 0.001						
					7.05	0.10	< 0.01	< 0.01	0.40	< 0.01	< 0.01	< 0.01	0.11	< 0.001
2237	0815132	081513208	1015	68	< 0.001	< 0.001	2 PPM	< 0.001						
					7.05	0.10	< 0.01	< 0.01	0.40	< 0.01	< 0.01	< 0.01	0.11	< 0.001
2237	0815132	081513209	1015	68	< 0.001	< 0.001	2 PPM	< 0.001						
					7.05	0.10	< 0.01	< 0.01	0.40	< 0.01	< 0.01	< 0.01	0.11	< 0.001
	0815132	081513210	1013	68	< 0.001	< 0.001	2 PPM	< 0.001						
					7.05	0.10	< 0.01	< 0.01	0.40	< 0.01	< 0.01	< 0.01	0.11	< 0.001
					< 0.001	< 0.001	2 PPM	< 0.001						

PAQUETS:

POIDS
NET
WEIGHT

PIECES

COURROIE:

BOIS:

POIDS BRUT:

BUNDLES:

STRAP:

WOOD:

GROSS WEIGHT:

LES LINGOTS TR-L0K 23 KG. LES LINGOTS EN FORME DE T. LES GUEUSES. LES LINGOTS DE LAMINAGE MIS AU REBUT ET AUTRES LINGOTS DE REFUSION ONT TENDANCE A FORMER DES CAVITES SUSCEPTIBLES D'EMPRISONNER DE L'EAU. POUR ELIMINER L'HUMIDITE AVANT LEUR EMPLOI DANS TOUT PROCÉDÉ DE FUSION ET POUR PREVENIR LES RISQUES D'EXPLOSION, LES LINGOTS DEVRAIENT ETRE SOUMIS A UN SECHAGE INTENSIF PAR CHAUFFAGE PRELIMINAIRE AVANT DE LES INCORPORER A DU METAL EN FUSION. / TR-L0K 23 KG INGOT, TEE INGOT, SOWS, SCRAPPED SHEET INGOT AND OTHER INGOT FOR REMELTING ARE PRONE TO THE FORMATION OF SHRINKAGE CAVITIES WHICH WILL PERMIT ENTRAPMENT OF WATER. TO ELIMINATE MOISTURE PRIOR TO USE IN ANY MELTING OPERATION AND TO SAFEGUARD AGAINST POSSIBLE EXPLOSION HAZARDS, INGOTS SHOULD BE THOROUGHLY DRIED BY PREHEATING BEFORE LOADING THEM INTO MOLTEN METAL.

NORMAND PRIVE

L'EXACTITUDE DE CES ANALYSES EST DANS LES NORMES DES LIMITES COMMERCIALES.
THE ANALYSES HEREIN ARE ACCURATE WITHIN COMMERCIAL LIMITS.